

Work Order ID 150105

Wednesday, August 24, 2016 11:32:20 AM

150105

Page 1

Item ID: D350-616-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Full Emergency Litter

Start Date: 8/10/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **AUG 24 2016**

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D350-616	H
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DAS 6 9-89**SEP 22 2016***Label***DAS 21 9-89***16-09-23*

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-616-011
CHG007**SEP 26 2016****DAS 27 9-89**

101

0.00

101

Small Fab

Memo

0.08

Small Fab

1- Assemble as per Dwg D2370

2- Transfer drill using D4812-041 as template and open to size 0.257" as per
Dwg D2370 AND DT9935 DRILL JIG

3- Ensure fit of D4812-041 and remove for shipping

D4812-041 MUST STAY WITH LITTER FRAME

4- Deburr

1 FF **SEP 22 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coor. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 150105

Wednesday, August 24, 2016 11:32:20 AM

150105

Page 2

Item ID: D350-616-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Full Emergency Litter

Start Date: 8/10/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

105

QC5- Inspect part completeness to step on W/O

0.00

105

QC

Memo

0.00

Quality Control

DAS
38
9-89
SEP 22 2016

119

Pick Kit

0.00

119

Packaging

Memo

0.00

Packaging

/ SEP 22 2016

DAS
6 28
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

SEP 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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OTHER : ☐					

Work Order ID 150105

Wednesday, August 24, 2016 11:32:20 AM

150105

Page 3

Item ID: D350-616-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Full Emergency Litter

Start Date: 8/10/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-616-011

Location: _____

PPP Rev: _____

*SEP 19 034*DAS
27 28
9-89 9-89

SEP 26 2016

140

0.00

140

QC

QC21- Final Inspection - Work Order Release

Memo

0.02

DAS
21
9-89

SEP 26 2016

Quality Control

DAS
21
9-89

SEP 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

Wednesday, August 24, 2016 11:32:24 AM

Page 1

Work Order ID: 150105

150105

Parent Item: D350-616-011

D350-616-011

Parent Item Name: Full Emergency Litter

Start Date: 8/10/2016

Required Date: 8/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP E03.04.04ReformatKJ/RF
IPP Rev:F 08-12-10 rev.E as per dwg DD verified by:ec IPP REV:G
13.05.21 AS PER DWG REV.G DD VERF:JLM IPP REV:H 16.04.19
NOW @ CHG007 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2370-1 *D2370-1* Litter Frame Assembly		Manufactured	No				Each	1.0000	**	DAS 30 9-89			SEP 22 2011
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST208		1							
				146272		1							
D350-616-013 *D350-616-013* Deck Plate & Tie Down		Manufactured	No				Each	1.0000	**	1			SEP 22 2016
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG028		1							
				147883		1							
D4812-041 *D4812-041* Patient Stop Assembly		Manufactured	No				Each	2.0000	**	DAS 30 9-89			SEP 22 2016
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST381		2							
				146295		2							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order ID 150105

150105

Page 1

Wednesday, August 24, 2016 11:32:20 AM

Item ID: D350-616-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*

Item Name: Full Emergency Litter

Start Date: 8/10/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: DAS 21 8-20 Date: AUG 24 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-616	H								
100	Document Control	0.00							

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile and create labels per PPP D350-616-011
 CHG007

0.00

SEP 22 2016

DAS
21
9-89

SEP 23 2016

101

0.00

101

Small Fab

Small Fab

Memo

1- Assemble as per Dwg D2370

0.08

2- Transfer drill using D4812-041 as template and open to size 0.257" as per
 Dwg D2370 AND DT9935 DRILL JIG

3- Ensure fit of D4812-041 and remove for shipping

D4812-041 MUST STAY WITH LITTER FRAME

4- Deburr

SEP 22 2016